

Date: Thursday, 02/04/2009 2:29:00 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 46891		
Estimate Number	: 12811		
P.O. Number	:	Part Number	: D35921
This Issue	: 02/04/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3592 REV.B
First Issue	: / /	Project Number	: N/A
Previous Run	: 44666	Drawing Revision	: B
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 15/04/2009
Checked & Approved By	: <u>Jul 09.04.03</u>	Qty:	20 Um: Each
Comment	: Est Rev:A New Issue 07-03.26 ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S125	6061-T6 .125 Sheet
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Comment: Qty.: 0.1460 sf(s)/Unit Total: 2.9190 sf(s)
 6061-T6 .125 Sheet
 Batch: 110062

Grain must be Along 4.63**

ml

09 04 08

(20)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3592
 *****ENSURE GRAIN IS AT 45 DEG AS PER DEO D3592-b-1*****
 Dwg Rev: B
 Prog Rev: B

2-Deburr if necessary

ml

09 04 08

(20)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ml 09 04 08

(20)

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

S 09/04/08

ccntes

(20)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D3592 using DT8949

SB 09/04/13

(20)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 2:29:00 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 46891

Part Number: D35921

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

80910415 counter x20

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: *Pat*

9/4/16

20

SB

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/16

Job Completion



MF 09-04-16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

65 49

DART AEROSPACE LTD		Work Order: 46891
Description: Bracket		Part Number: D3592-1
Inspection Dwg: D3592	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
☒ **First Article**
☐ **Prototype**

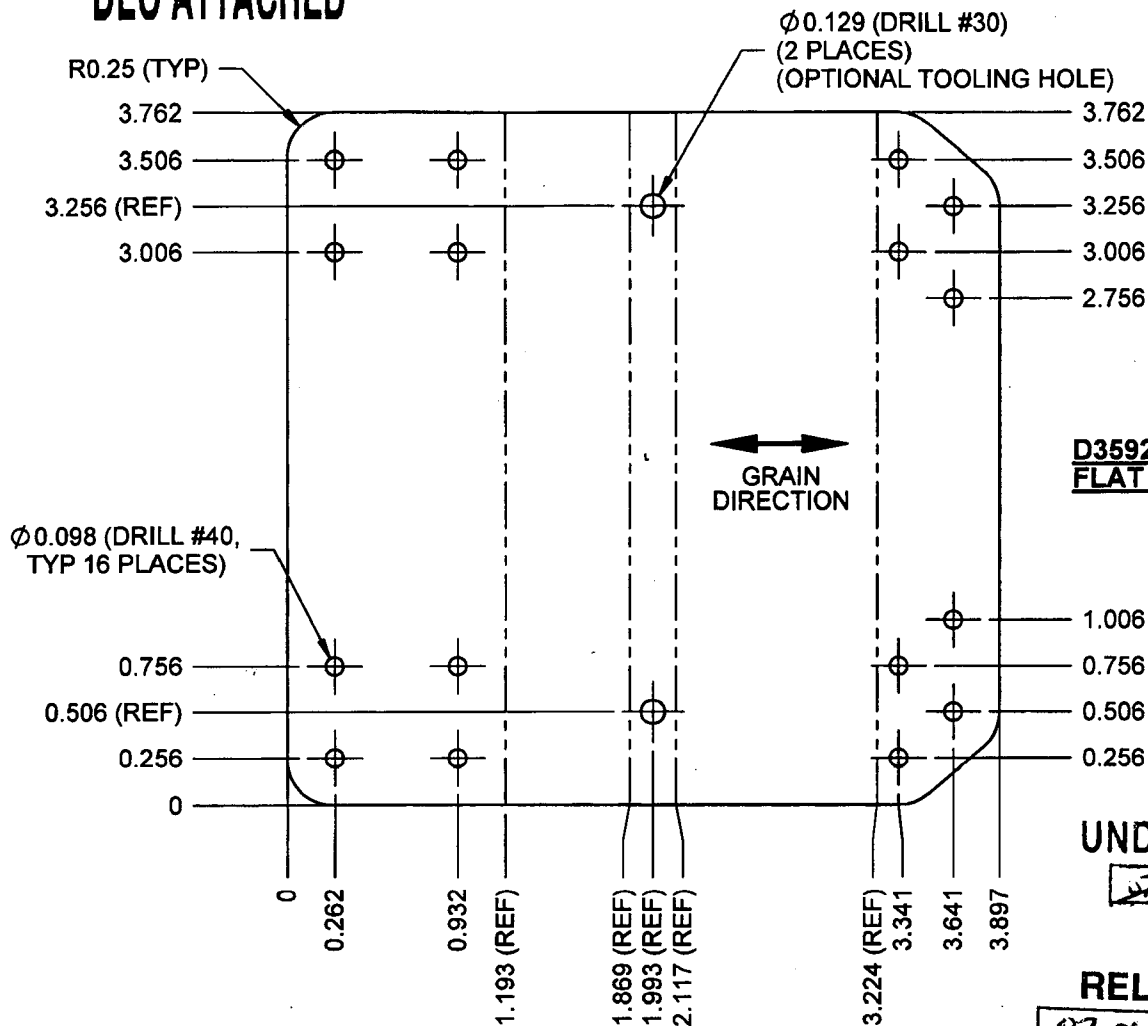
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.130	✓		vern	
Ø0.098	+0.004/-0.001	0.098	✓		vern	
0.506	+/-0.010	0.508	✓		vern	
0.256	+/-0.010	0.254	✓		vern	
0.756	+/-0.010	0.762	✓		vern	
3.256	+/-0.010	3.263	✓		vern	
0.262	+/-0.010	0.260	✓		vern	
1.993	+/-0.010	1.991	✓		vern	
3.341	+/-0.010	3.341	✓		vern	
3.641	+/-0.010	3.647	✓		vern	
3.897	+/-0.010	3.907	✓		vern	
3.762	+/-0.010	3.770	✓		vern	

Measured by: ml.ml	Audited by: S	Prototype Approval:	N/A
Date: 09.04.08	Date: 09/04/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.15	New Issue	KJ/EC/DD	

DART

DESIGN <i>qp</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>qp</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3592	REV. B SHEET 1 OF 1
DATE 07.05.31		TITLE PLATE	SCALE 1:1
A	07.01.15	NEW ISSUE	
B	07.05.31	TOOLING HOLES ADDED	

DEO ATTACHED**D3592-1F
FLAT PATTERN****UNDER REVIEW****RELEASED****BEND DETAIL
SCALE 1:2**SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPYWORK ORDER
NO. **46891****D3592-1 PLATE****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.125" THICK (QQ-A-250/11, REF DART SPEC. M6061T6S125)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 MAX

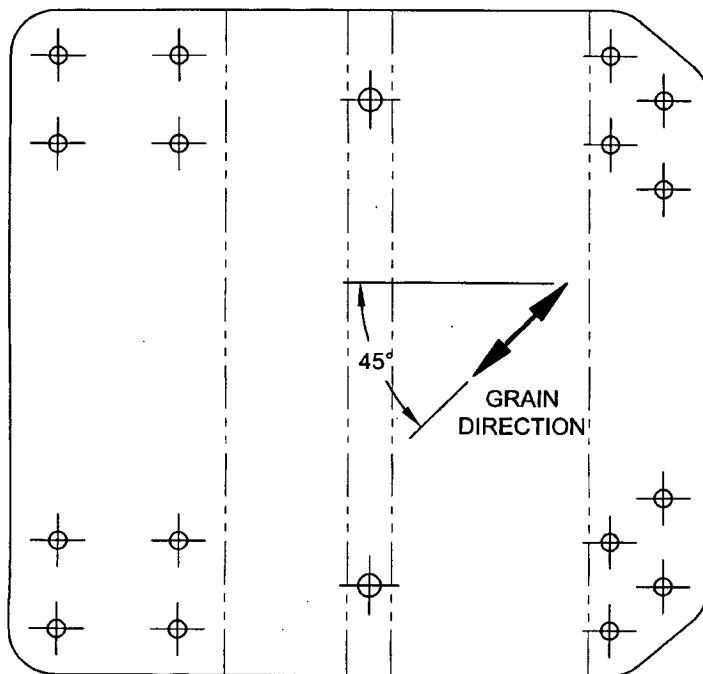
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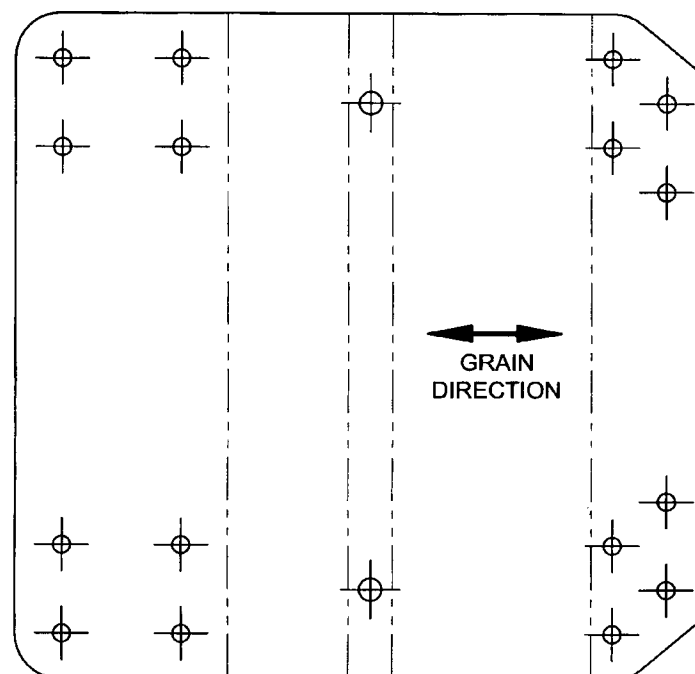
DRAWING NO. D3592	TITLE PLATE	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3592-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED b	MFG. APPR. AD	APPROVED W.P.		DE APPR. -H-		
DATE 08.09.11	DATE 08.09.11	DATE 08/09/11	DATE 08/09/11		DATE 08/09/11		

MODIFY GRAIN DIRECTION AS SHOWN BELOW TO PREVENT CRACKING WHEN WELDING AT ASSEMBLY (SEE CAR 08-026).

IS:



WAS:



ALL OTHER INFORMATION REMAINS UNCHANGED

RELEASED
08.09.17

NO. 408913
WITHOUT THE
ENGINEER'S
RETURN TO
UNCONTROLLED COPY
SUBJECT TO A/N